

DART AEROSPACE LTD		Work Order:	24765
Description: Wearpad		Part Number:	D3339- 3 3
Drawing: D3339 Rev. a		Qty:	
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	UL	05.11.15	6
2	PG	Issue P/O: <u>2008674</u> Email or ship DXF file to vendor Laser Cut per Dwg D3339 flat pattern D3339-1 Material release note required	UL	05.11.15	6
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	UL	05.11.15	6
4	QC6	Inspect dimensions	UL	05.11.15	6
5	GB	Deburr if necessary	UL	05.11.15	6
6	GB	Form on Brake as per Dwg D3339 using Jigs DT 826 and DT 8261	CPL	05.11.15	6
7	QC5	Inspect work to Step 7	UL	05.11.15	6
6	GB	Weld hradcoat 7560 per dwg D3339 using DT 8210 & 8210 layout 916 Pick: QTY description batch: A/R 7560 hradcoat 118838	CPL	05.11.15	6
7	QC9	Inspect welds	UL	05.11.15	6
8	FP	Powder Coat Grey sandtex (Ref. 4.3.5.6) per QSI 005 4.3	UL	05.11.16	6
9	QC3	Inspect Powder Coat	UL	05.11.16	6
10	FP	Identify and Stock Loc 416	UL	05.11.18	6
11	AC	Cost / part:	UL	05.11.18	6
12	DC	Close W/O Inspect Level 21	UL	05.11.22	6

Rev	Date	Change	Revised By	Approved
A	05.11.10	Preliminary issue	EC	EC

PRELIMINARY ISSUE

Remnant Change as shown on Step 6; ~~Step 6~~ Second Step 6.
JMM 05.11.14.

CONTROLLED COPY



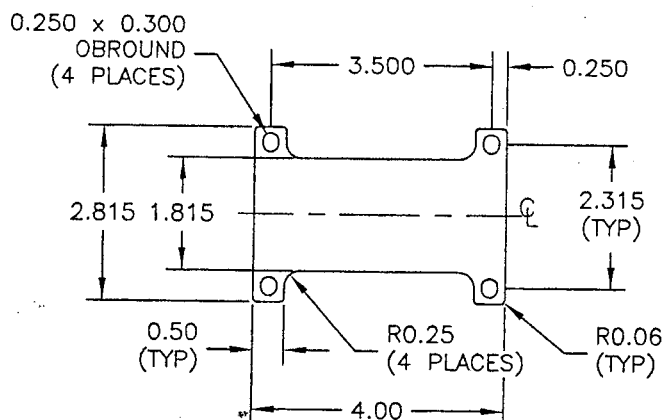
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. A SHEET 1 OF 3
DATE 05.06.06		TITLE REPLACEMENT WEARPAD	SCALE 1:3
A	05.06.06	NEW ISSUE	

RELEASED

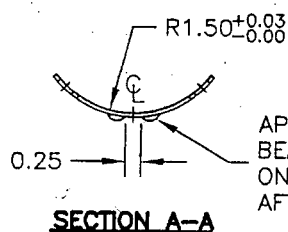
05.09.16 *[Signature]*

UNDER REVIEW

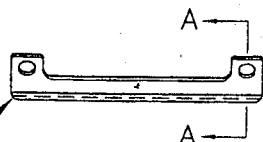
05-10-05 *[Signature]*



D3339-1 FLAT PATTERN

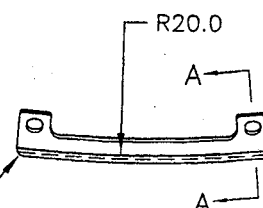


APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-3T1
AFTER FORMING
(SEE SECTION A-A)



D3339-3 CENTER WEARPAD
(MADE FROM D3339-1)

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-5T1
AFTER FORMING
(SEE SECTION A-A)



D3339-5 FORWARD WEARPAD
(MADE FROM D3339-1)

D3339-1/-3/-5 WEARPAD

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063' MAX

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 15, 2005
02:18 pm

Work Order No	:	0024765	Department Code:	
Project Name	:	D3340-1	Burden Flags	: NNNNNNN
Project For	:	WK546	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3340-1	Invoice Number	:
Description	:	Fwd Skidtube Protector	Invoice Amount	: 0.00
Manufactured	:	No	Order Entry No	:
Amount Req'd	:	0	OE Value	: 0.00
Amount Done	:	0	Est Margin	: 0.000%
Start Date	:	11-15-05	Actual Margin	: 0.000%
Est Finish Date	:			
Act Finish Date	:			
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Date: Monday, 11/21/2005 10:22:11 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 24765	
Estimate Number : 10788	
P.O. Number :	Part Number : D33393
This Issue : 11/21/2005 S.O. No. :	Drawing Number : D3339 REV A
Prsht Rev. : NC	Project Number :
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By : _____	Due Date : 11/28/2005 Qty: 6 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 05-11-10 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: _____
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg
 Possible supplier: Ind. Laser
 Material release note is required.

2.0	D33393F	WEARPAD-FLAT
-----	---------	--------------

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Deburr if necceray

2-Form as per Dwg D3339 using DT8326 and DT8261

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 10:22:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 24765

Part Number: D33393

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Hard coat 7560 per Dwg D3339,use DT8210 & DT8810 Layout Jig

A/R 7560 Hardcoat Batch: _____

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries